

Date: Wednesday, 5/31/2006 3:16:25 PM  
 User: Kim Johnston

## Process Sheet

23

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHROUD AIRFLOW HEATER SYSTEM
<b>Job Number</b> :	26900		
<b>Estimate Number</b> :	12345		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D206746011
<b>This Issue</b> :	5/31/2006	<b>Drawing Number</b> :	IIN D206-746 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	26901	<b>Material</b> :	N/A
<b>Written By</b> :	SEA COMMENT RECDW	<b>Due Date</b> :	6/7/2006
<b>Checked &amp; Approved By</b> :	06.05.31	<b>Qty:</b>	1 Um: Each
<b>Comment</b> :	est rev.A 06.03.23 new issue EC est rev.B 06.04.26 updated pick list EC Est Rev:C 06-05-24 Per Rev A JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D206-746-011 CHG001

KS 06/06/05 (1)

2.0	26900A	REAR OVERHEAD PASSENGER MODIFICATION KIT
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**Comment:** Sub-Component REAR OVERHEAD PASSENGER MODIFICATION KIT

3.0	D3467041	SHROUD ASSEMBLY
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHROUD ASSEMBLY

Batch: ~~B26780~~ B26780 ✓

4.0	D34681	SEAL
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

Batch: B26901 ✓

5.0	D34683	LARGE SEAL STRIP
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LARGE SEAL STRIP

Batch: B26982 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D34685

SEAL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SEAL

Batch: B26953 ✓

7.0

D3469041

SHUT-OFF VALVE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHUT-OFF VALVE ASS'Y

Batch: B26954 ✓

8.0

D3471041

BLOWER MOTOR SUPPORT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BLOWER MOTOR SUPPORT

Batch: B26955 ✓

9.0

D34715

STIFFENER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

Batch: B27455 ✓

10.0

D3473041

BLOWER INLET ADAPTER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BLOWER INLET ADAPTER

Batch: B26956 ✓

11.0

D3475041

DUMP OUTLET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP OUTLET

Batch: B26616 ✓

12.0

D34755

SCREEN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screen

Batch: B27453 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34757

scoop outlet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

scoop outlet

Batch: B27543

14.0

D34759

OUTLET GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

OUTLET GASKET

Batch: B27456 ✓

15.0

D3476041

blower motor adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

blower motor adapter

Batch: B26957-1 ✓

16.0

D3477041

Blower Motor Inlet Adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blower Motor Inlet Adapter

Batch: B26597 ✓

17.0

D3478041

AIR INLET ADAPTER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET ADAPTER

Batch: B26537 ✓

18.0

D34785

SCREEN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SCREEN

batch: B27454 ✓

19.0

D34787

INLET GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

INLET GASKET

Batch: B27457 ✓

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D34789	INLET SCOOP
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
INLET SCOOP

Batch: B27542

21.0	D3481041	Shut off valve bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Shut off valve bracket

Batch: B26962 ✓

22.0	D34821	INLET INSULATION SOCK
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
INLET INSULATION SOCK

Batch: B26387 ✓

23.0	D34823	OUTLET INSULATION SOCK
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
OUTLET INSULATION SOCK

Batch: B26966 ✓

24.0	D34825	HOSE INSULATION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
HOSE INSULATION

Batch: B26387 ✓

25.0	D34827	HOSE INSULATION
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
HOSE INSULATION

Batch: B26387 ✓

26.0	D34829	HOSE INSULATION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
HOSE INSULATION

Batch: B26387 ✓

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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D348211	HOSE INSULATION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: B26969 ✓

28.0	D348213	HOSE INSULATION
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HOSE INSULATION

Batch: B26387 ✓

29.0	D34831	DUMP VALVE PLACARD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP VALVE PLACARD B26376 ✓

30.0	D34833	SHUT-OFF VALVE PLACARD
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SHUT-OFF VALVE PLACARD

Batch: B26377 ✓

31.0	D34835	warning label
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DUMP VALVE PLACARD

Batch: B26471 ✓

32.0	26D71	Blower Motor
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

JANITROL BLOWER MOTOR ASSEMBLY

Batch: ~~A21114~~ M101144

33.0	31903	BLUE TERMINAL AMP
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BLUE TERMINAL AMP

Batch: M101053 ✓

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Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN33A

Bolt



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)  
Bolt M19444 ✓

35.0

AN35 A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
BOLT per Marc B. Al  
Batch: M15205 ✓ 26/06/08

36.0

AN9604L

washer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)  
washer M 14606 ✓

37.0

AN9608

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
WASHER (A/R)  
Batch: M19356 QTY 10 ✓

38.0

AN96010

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Washer  
Batch: M5519 ✓

39.0

AN96010L

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)  
Washer M18235 ✓

40.0

CR322343

Cherry Rivet



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Cherry Rivet  
Batch: M12706 ✓

W/O:		WORK ORDER CHANGES					
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Job Number: 26900

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Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

DCS549

TURN-TO-LOCK CONTROL



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PUSH/PULL CONTROL

Batch: M100962 ✓ 1mcp M100866 ✓ 1mcp

42.0

M227591169

16GA ELECTRICAL WIRE, 120" LONG



Comment: Qty.: 1.0000 ft(s)/Unit Total : 1.0000 ft(s)

16GA ELECTRICAL WIRE, 120" LONG

Batch: M101053 ✓

43.0

MS21083N08

NUT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty (A/R) NUT

Batch: M101356 ✓

44.0

MS21919DG3

CLAMP



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Qty (A/R) CLAMP

Batch: M100798 ✓

45.0

MS21919DG44

CLAMP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CLAMP

Batch: M100771 ✓

46.0

MS21919DG48

CLAMP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP

Batch: M100798 ✓

W/O:		WORK ORDER CHANGES					
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

MS24166D1

RELAY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

RELAY

Batch: M100202 ✓

48.0

MS2524475

CIRCUIT BREAKER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CIRCUIT BREAKER

Batch: M100097 ✓

49.0

MS2524415

BREAKER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BREAKER

Batch: M100097 ✓

50.0

MS270390816

SCREW PAN HD



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Qty (A/R) SCREW PAN HD

Batch: M19605 ✓

51.0

MS3505822

SWITCH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

SWITCH

Batch: M100202 ✓

52.0

NAS43DD316N

SPACER



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Qty (A/R) SPACER

Batch: M19402 ✓

53.0

NAS43DD348FC

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Batch: M17280 ✓

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

NAS679A3

NUT SELF LOCK



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

NUT SELF LOCK

Batch: M100651 ✓

55.0

QS20044S

CLAMP



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLAMP

Batch: M100202 ✓

56.0

QS20056S

CLAMP



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) ✓

CLAMP

Batch: M100202 1mc M100857 7mc ✓

57.0

RTV106

RED HI-TEMPERATURE ADHESIVE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty (A/R) RED HI-TEMPERATURE ADHESIVE

Batch: M100789 ✓

58.0

SCEET11

SCEET



Comment: Qty.: 12.0000 f(s)/Unit Total : 12.0000 f(s)

SCEET

Batch: M100807 → 9P150

4  
PICKED → M101282

1x5 1x4

2x2 ✓

59.0

SCEET12

HOSE 3" DIAMETER



Comment: Qty.: 11.0000 f(s)/Unit Total : 11.0000 f(s)

HOSE 3" DIAMETER

Batch: M100788 ✓

60.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 06/06/15

P.P.P D206-746-011

REUB

06/06/15

①

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SHROUD AIRFLOW HEATER SYSTEM

Job Number: 26900

Part Number: D206746011

Job Number:



Seq. #:

Machine Or Operation:

Description :

61.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*SP* 25/06/16

Job Completion



*12* 06.06/16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## 7.0 PARTS LIST

Qty -011	Qty -041	Part Number	Description
X		D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X	D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		D3467-041	SHROUD ASSEMBLY (CAM-1984-004)
2		D3468-1	SEAL
1		D3468-3	LARGE SEAL STRIP
2		D3468-5	SEAL STRIP
1		D3469-041	SHUT-OFF VALVE ASSEMBLY (CAM-1984-005)
1		D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
1		D3471-5	STIFFENER (CAM-1984-008-4)
	2	D3472-041	CABIN HEAT OUTLET DEFLECTOR (CAM-1984-012)
	2	D3472-5	DOUBLER (CAM-1984-017-6)
1		D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
1		D3475-041	DUMP OUTLET (CAM-1984-013-27)
1		D3475-5	SCREEN (CAM-1984-013-25)
1		D3475-7	SCOOP OUTLET (CAM-1984-013-22)
1		D3475-9	GASKET
1		D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
1		D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
1		D3478-041	AIR INLET ADAPTER (CAM-1984-016)
1		D3478-5	SCREEN
1		D3478-7	GASKET
1		D3478-9	INLET SCOOP
	2	D3479-041	INLET ADAPTER (CAM-1984-017-22)
	2	D3480-041	EYEBALL INLET ADAPTER (CAM-1984-017-23)
	2	D3480-043	EYEBALL ADAPTER (CAM-1984-017-19)
	2	D3480-7	GASKET (CAM-1984-017-21)
1		D3481-041	SHUT-OFF VALVE BRACKET (CAM-1984-018)
1		D3482-1	INLET INSULATION SOCK (CAM-003-34)
1		D3482-3	OUTLET INSULATION SOCK (CAM-003-34)
1		D3482-5	HOSE INSULATION (CAM-003-34)
2		D3482-7	HOSE INSULATION (CAM-003-34)
1		D3482-9	HOSE INSULATION (CAM-003-34)
1		D3482-11	HOSE INSULATION (CAM-003-34)
1		D3482-13	HOSE INSULATION (CAM-003-34)
1		D3483-1	DUMP VALVE PLACARD (CAM-003-21)
1		D3483-3	SHUT-OFF VALVE PLACARD (CAM-003-22)
1		D3483-5	WARNING PLACARD

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 26900

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Revision: A  
 Date: 06.05.16

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## 7.0 PARTS LIST (CONTINUED)

QTY -011	QTY -041	Part Number	Description
X		D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X	D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		26D71	JANITROL BLOWER MOTOR ASS'Y (EQUIV. 26D71-1)
4		320565	RING CONNECTOR (EQUIV. 31903 BLUE TERMINAL AMP)
	2	9977009-4	BELL EYEBALL VENT
26		AN3-3A	BOLT
	8	AN3-4A	BOLT
3		AN3-5	BOLT
5		AN960-4L	WASHER
10		AN960-8	WASHER
3		AN960-10	WASHER
26	16	AN960-10L	WASHER
	24	CR2248-4-2	RIVET (EQUIV. NAS1739B4-2)
5		CR2539-4-03	RIVET (EQUIV. CR3223-4-03)
2		DCS54-9	PUSH/PULL CONTROL
	1	HA-000611	CARBON MONOXIDE INDICATOR
1		M22759/16-16-9	16GA ELECTRICAL WIRE, 120" LONG
10		MS21083-N08	NUT
10		MS21919DG-3	CLAMP
2		MS21919DG-44	CLAMP
1		MS21919DG-48	CLAMP
1		MS24166D1	RELAY
1		MS25244-7.5	CIRCUIT BREAKER
1		MS25244-15	CIRCUIT BREAKER
10		MS27039-0816	SCREW
	8	MS27039-1-10	SCREW
1		MS35058-22	SWITCH
10		NAS43DD3-16N	SPACER
2		NAS43DD3-48FC	SPACER
	12	NAS1738B4-2	RIVET
6	8	NAS679A3	NUT
6		QS200 44 S	CLAMP
8		QS200 56 S	CLAMP
12'		SCEET 11	Ø2.75" HOSE
11'		SCEET 12	Ø3.00" HOSE
	4	TY-527M	TY RAP

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Revision: A  
 Date: 06.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_